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**RBEA62309-3**  
**Job Sheet 197483**



**Part No:** RBEA62309-3

**Job Qty:** 18 pcs

17 MLL

**Part Name:** Stiffener Assembly



**Part Weight:** 0 lbs

**Status:** New

**Priority:** Medium

**Job Created:** 7/9/19

**Job Tracking No:**

**Due Date:** 8/9/19

**Created By:** Marie Lajeunesse

**Type:** SOLD

**Description:**

**Note:** DWG RBEA62309 Rev.T IPP Rev. A 19.02.01 New issue DP Verify DD/IPP Rev.B 19.02.28 drawing revision  
DP Verify DD/IPP Rev. C 19.04.01 drawing revision DP Verify DD

**Ship Via:**

### Bill of Materials

### Job Routing

| Op No | Operation                   | Qty    | Start Date | Due Date | Standard  |         | Workcenter/Supplier   |           | Sign-off                         |
|-------|-----------------------------|--------|------------|----------|-----------|---------|-----------------------|-----------|----------------------------------|
|       |                             |        |            |          | Setup Hrs | Run Hrs | Workcenter / Supplier | Lead Time |                                  |
| 100   | Small Fab - 1               | 18 pcs | 8/9/19     |          | 0.00      | 3.60    | Small Fab - 1         |           | GP 19-10-17                      |
|       |                             |        |            |          |           |         | Small Fab - 2         |           |                                  |
|       |                             |        |            |          |           |         | Small Fab - 3         |           |                                  |
|       |                             |        |            |          |           |         | Small Fab - 4         |           |                                  |
|       |                             |        |            |          |           |         | Small Fab - 5         |           |                                  |
|       |                             |        |            |          |           |         | Small Fab - 6         |           |                                  |
|       |                             |        |            |          |           |         | Small Fab - 7         |           |                                  |
| 110   | QC 5                        | 18 pcs | 8/9/19     |          | 0.00      | 0.00    | QC 5 - 10             |           | DCT 18 2019<br>DAS<br>40<br>9-08 |
|       |                             |        |            |          |           |         | QC 5 - 12             |           |                                  |
|       |                             |        |            |          |           |         | QC 5 - 17             |           |                                  |
|       |                             |        |            |          |           |         | QC 5 - 18             |           |                                  |
|       |                             |        |            |          |           |         | QC 5 - 19             |           |                                  |
|       |                             |        |            |          |           |         | QC 5 - 22             |           |                                  |
|       |                             |        |            |          |           |         | QC 5 - 24             |           |                                  |
|       |                             |        |            |          |           |         | QC 5 - 3              |           |                                  |
|       |                             |        |            |          |           |         | QC 5 - 43             |           |                                  |
|       |                             |        |            |          |           |         | QC 5 - 49             |           |                                  |
|       |                             |        |            |          |           |         | QC 5 - 51             |           |                                  |
|       |                             |        |            |          |           |         | QC 5 - 58             |           |                                  |
|       |                             |        |            |          |           |         | QC 5 - 68             |           |                                  |
|       |                             |        |            |          |           |         | QC 5 - 9              |           |                                  |
|       |                             |        |            |          |           |         | QC 5 - 50             |           |                                  |
|       |                             |        |            |          |           |         | QC 5 - 30             |           |                                  |
|       |                             |        |            |          |           |         | QC 5 - 40             |           |                                  |
|       |                             |        |            |          |           |         | QC 5 - 61             |           |                                  |
|       |                             |        |            |          |           |         | QC 5 - 81             |           |                                  |
| 120   | Packaging 3-1 - Stock - B4B | 18 pcs | 8/9/19     |          | 0.00      | 0.00    | Packaging 3 - 1 - B4B |           |                                  |
|       |                             |        |            |          |           |         | Packaging 3 - 2 - B4B |           |                                  |
|       |                             |        |            |          |           |         | Packaging 3 - 3 - B4B |           |                                  |
|       |                             |        |            |          |           |         | Packaging 3 - 4 - B4B |           |                                  |

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|                |        |        |           |                        |  |
|----------------|--------|--------|-----------|------------------------|--|
|                |        |        |           | Packaging 3 - 5 - B4B  |  |
|                |        |        |           | Packaging 3 - 6 - B4B  |  |
|                |        |        |           | Packaging 3 - 7 - B4B  |  |
|                |        |        |           | Packaging 3 - 8 - B4B  |  |
|                |        |        |           | Packaging 3 - 9 - B4B  |  |
|                |        |        |           | Packaging 3 - 10 - B4B |  |
|                |        |        |           | Packaging 3 - 11 - B4B |  |
|                |        |        |           | Packaging 3 - 12 - B4B |  |
|                |        |        |           | Packaging 3 - 13 - B4B |  |
|                |        |        |           | Packaging 3 - 14 - B4B |  |
|                |        |        |           | Packaging 3 - 15 - B4B |  |
|                |        |        |           | Packaging 3 - 16 - B4B |  |
|                |        |        |           | Packaging 3 - 17 - B4B |  |
|                |        |        |           | Packaging 3 - 18 - B4B |  |
|                |        |        |           | Packaging 3 - 19 - B4B |  |
|                |        |        |           | Packaging 3 - 20 - B4B |  |
|                |        |        |           | Packaging 3 - 21 - B4B |  |
|                |        |        |           | Packaging 3 - 22 - B4B |  |
|                |        |        |           | Packaging 3 - 23 - B4B |  |
|                |        |        |           | Packaging 3 - 24 - B4B |  |
|                |        |        |           | Packaging 3 - 25 - B4B |  |
|                |        |        |           | Packaging 3 - 26 - B4B |  |
|                |        |        |           | Packaging 3 - 27 - B4B |  |
|                |        |        |           | Packaging 3 - 28 - B4B |  |
|                |        |        |           | Packaging 3 - 29 - B4B |  |
|                |        |        |           | Packaging 3 - 30 - B4B |  |
|                |        |        |           | Packaging 3 - 31 - B4B |  |
|                |        |        |           | Packaging 3 - 32 - B4B |  |
|                |        |        |           | Packaging 3 - 33 - B4B |  |
|                |        |        |           | Packaging 3 - 34 - B4B |  |
|                |        |        |           | Packaging 3 - 35 - B4B |  |
|                |        |        |           | Packaging 3 - 36 - B4B |  |
| 130 QC 21 - SA | 18 pcs | 8/9/19 | 0.00 0.00 | QC 21 - SA - 21        |  |
|                |        |        |           | QC 21 - SA - 70        |  |

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OCT 22 2019

Part Op 100 - Assemble as per DWG. See note 7.  
 Descriptions: 110 - QC5- Inspect part completeness to step on W/O  
 120 - Identify as per dwg & Stock Location:  
 130 - QC21- Final Inspection - Work Order Release

## Job BOM

| Part / Item | Component Name                              | Quantity      | Operation         | Container            |
|-------------|---------------------------------------------|---------------|-------------------|----------------------|
| 93286A013   | Aluminum Washer 0.265" ID, X 0.688" OD.     | 144 Ea (8 ea) | 100-Small Fab - 1 | 5152094x28-22 620x37 |
| 97484A341   | Aluminum Solid Rivets 1/4" Dia. X 3/8" Long | 144 Ea (8 ea) | 100-Small Fab - 1 | 5169784x44 205054    |
| DTSP10002   | Handle                                      | 36 pcs (2 ea) | 100-Small Fab - 1 | 190022x19 x71.       |
| RBEA62309-4 | Stiffener                                   | 18 pcs (1 ea) | 100-Small Fab - 1 | 218071x9             |

## Job Allocations

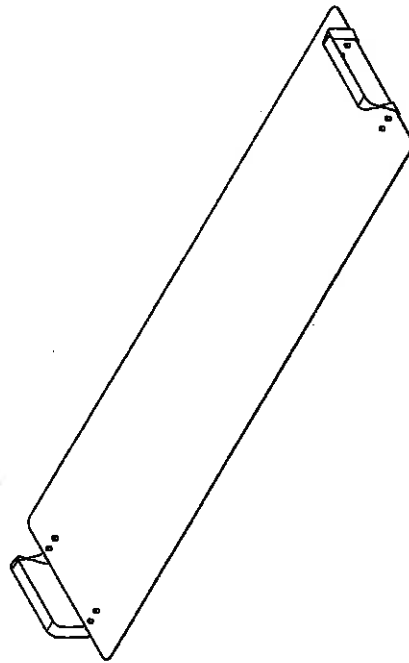
| Operation         | Component Part | Required | Inventory | Allocated |
|-------------------|----------------|----------|-----------|-----------|
| 100-Small Fab - 1 | 93286A013      | 144      | 168       | 0         |
|                   | 97484A341      | 144      | 49        | 0         |
|                   | DTSP10002      | 36       | 28        | 0         |
|                   | RBEA62309-4    | 18       | 5         | 0         |

## Part Specifications

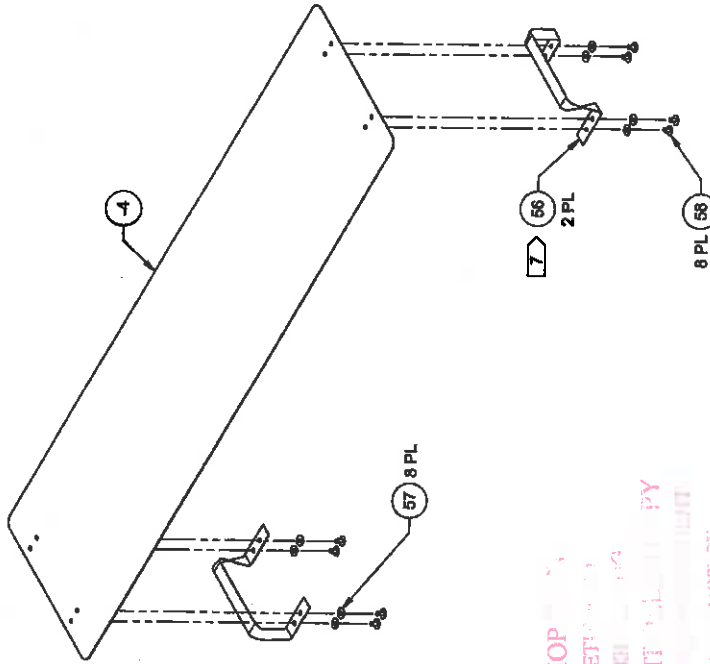
Specifications could not be found.

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| ITEM # | QTY | PART #                       | PART TITLE                                                   |
|--------|-----|------------------------------|--------------------------------------------------------------|
| -4     | 1   | RBEA62309-4                  | STIFFENER                                                    |
| 56     | 2   | DTSP10002                    | HANDLE                                                       |
| 57     | 8   | McMaster983286A013 OR EQUIV. | ALUMINUM WASHER 0.285" ID. X 0.865" OD. X 0.030"-0.055" THK. |
| 58     | 8   | McMaster997484A341 OR EQUIV. | ALUMINUM SOLID RIVETS 1/4" DIA. X 3/8" LG.                   |



**RBEA62309-3 STIFFENER ASSEMBLY**



SHOP  
RETURN  
ENCH  
UNCONTY  
SUBJECT  
WITH NOTICE  
W/OUT NOOR  
NO. 197483 HCS  
19-07-09

- NOTES:
- 1) MATERIAL: N/A
  - 2) HEAT TREAT: N/A
  - 3) FINISH: N/A
  - 4) TOLERANCES: X.X =  $\pm 0.1"$  /  $\pm 1"$   
X.XX =  $\pm 0.01"$  /  $\pm 0.5"$   
X.XXX =  $\pm 0.005"$  /  $\pm 0.1"$   
X.XXXX =  $\pm 0.0005"$  /  $\pm 0.05"$   
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES =  $\pm 0.005"$
  - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 6) IDENTIFICATION: N/A
  - 7) INSTALL ITEMS 56 ONTO ITEM -4 USING ITEMS 58

|                                        |     |                                |           |
|----------------------------------------|-----|--------------------------------|-----------|
| DESIGN                                 | KPT | DATE                           | 3/27/2019 |
| DRAWN                                  | KPT |                                |           |
| CHECKED                                | KPT |                                |           |
| MFG. APPR.                             | DP  |                                |           |
| APPROVED                               | WY  |                                |           |
| TOOL PART #                            |     | RBEA62309                      |           |
| TITLE                                  |     | AS350355 FIELD MAINTENANCE KIT |           |
| DART AEROSPACE LTD                     |     | HAWKESBURY, ONTARIO, CANADA    |           |
| REV. T                                 |     | SHEET 6 OF 11                  |           |
| SCALE                                  |     | NTS                            |           |
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Entered: \_\_\_\_\_ Date: \_\_\_\_\_

**WORK ORDER NON-CONFORMANCE / ROUTE UPDATE**

NCR No. \_\_\_\_\_

Route update only ☐

| Job: _____                                                                                                                                                                                                                                                                                                                                                                                                                        |  | DISPOSITION                                                                                             |  | DEPARTMENT/PROCESS                                                                                             |  |                                                                                                                 |  |                                                                                                                                      |  |                                                                                                                                                     |  |                        |  |
|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--|---------------------------------------------------------------------------------------------------------|--|----------------------------------------------------------------------------------------------------------------|--|-----------------------------------------------------------------------------------------------------------------|--|--------------------------------------------------------------------------------------------------------------------------------------|--|-----------------------------------------------------------------------------------------------------------------------------------------------------|--|------------------------|--|
| Part No. _____                                                                                                                                                                                                                                                                                                                                                                                                                    |  | Rework <input type="checkbox"/><br>Scrap <input type="checkbox"/><br>Use-as-is <input type="checkbox"/> |  | Skid-tube <input type="checkbox"/><br>Machining <input type="checkbox"/><br>Large Fab <input type="checkbox"/> |  | Cross tube <input type="checkbox"/><br>Small Fab <input type="checkbox"/><br>Finishing <input type="checkbox"/> |  | Eng. (Non-AW) <input type="checkbox"/><br>Prod. Eng. Coord. <input type="checkbox"/><br>Rec/Store/Packaging <input type="checkbox"/> |  | Engineering <input type="checkbox"/><br>Water Jet <input type="checkbox"/><br>Supplier <input type="checkbox"/><br>Quality <input type="checkbox"/> |  |                        |  |
| Date: _____                                                                                                                                                                                                                                                                                                                                                                                                                       |  | Sequence #: _____                                                                                       |  | QTY Affected: _____                                                                                            |  | MIRB (QS042) _____                                                                                              |  |                                                                                                                                      |  |                                                                                                                                                     |  |                        |  |
| Description Work Order Deviation                                                                                                                                                                                                                                                                                                                                                                                                  |  |                                                                                                         |  | Disposition                                                                                                    |  |                                                                                                                 |  |                                                                                                                                      |  |                                                                                                                                                     |  |                        |  |
|                                                                                                                                                                                                                                                                                                                                                                                                                                   |  |                                                                                                         |  |                                                                                                                |  |                                                                                                                 |  |                                                                                                                                      |  |                                                                                                                                                     |  | Completed By           |  |
|                                                                                                                                                                                                                                                                                                                                                                                                                                   |  |                                                                                                         |  |                                                                                                                |  |                                                                                                                 |  |                                                                                                                                      |  |                                                                                                                                                     |  | Lead hand / Supervisor |  |
|                                                                                                                                                                                                                                                                                                                                                                                                                                   |  |                                                                                                         |  |                                                                                                                |  |                                                                                                                 |  |                                                                                                                                      |  |                                                                                                                                                     |  | QC / QA Coordinator    |  |
| <b>Root Cause</b>                                                                                                                                                                                                                                                                                                                                                                                                                 |  |                                                                                                         |  | <b>FAULT CATEGORY</b>                                                                                          |  |                                                                                                                 |  |                                                                                                                                      |  |                                                                                                                                                     |  |                        |  |
| <div>Operator <input type="checkbox"/></div> <div>Manufacturing Process <input type="checkbox"/></div> <div>Equip/Tooling <input type="checkbox"/></div> <div>Handling/Preservation <input type="checkbox"/></div> <div>Material <input type="checkbox"/></div> <div>Product Improvement <input type="checkbox"/></div> <div>Process Improvement <input type="checkbox"/></div> <div>Human Factors <input type="checkbox"/></div> |  |                                                                                                         |  | Pressure/Forced <input type="checkbox"/>                                                                       |  | Contamination <input type="checkbox"/>                                                                          |  | Power Loss/Surge <input type="checkbox"/>                                                                                            |  | Positioned Wrong <input type="checkbox"/>                                                                                                           |  |                        |  |
|                                                                                                                                                                                                                                                                                                                                                                                                                                   |  |                                                                                                         |  | Bending <input type="checkbox"/>                                                                               |  | Misaligned/off center <input type="checkbox"/>                                                                  |  | Folio/Program <input type="checkbox"/>                                                                                               |  | Outside Tolerance <input type="checkbox"/>                                                                                                          |  |                        |  |
|                                                                                                                                                                                                                                                                                                                                                                                                                                   |  |                                                                                                         |  | Crushing <input type="checkbox"/>                                                                              |  | BOM/Route <input type="checkbox"/>                                                                              |  | Grain Direction <input type="checkbox"/>                                                                                             |  | Drawing <input type="checkbox"/>                                                                                                                    |  |                        |  |
|                                                                                                                                                                                                                                                                                                                                                                                                                                   |  |                                                                                                         |  | Cracks <input type="checkbox"/>                                                                                |  | Broken/Damage/Defect <input type="checkbox"/>                                                                   |  | Weld <input type="checkbox"/>                                                                                                        |  | Finish <input type="checkbox"/>                                                                                                                     |  |                        |  |
|                                                                                                                                                                                                                                                                                                                                                                                                                                   |  |                                                                                                         |  | Crimp/Kink/Ripple/Wave/Twist <input type="checkbox"/>                                                          |  | Incomplete/Unclear Instructions <input type="checkbox"/>                                                        |  | Wrong Stock Pulled <input type="checkbox"/>                                                                                          |  | Part Lost/Missing <input type="checkbox"/>                                                                                                          |  |                        |  |
|                                                                                                                                                                                                                                                                                                                                                                                                                                   |  |                                                                                                         |  | Marks/Chatter <input type="checkbox"/>                                                                         |  | Drill Holes <input type="checkbox"/>                                                                            |  | Out of Sequence <input type="checkbox"/>                                                                                             |  | Misread <input type="checkbox"/>                                                                                                                    |  |                        |  |
|                                                                                                                                                                                                                                                                                                                                                                                                                                   |  |                                                                                                         |  | Mislabeled <input type="checkbox"/>                                                                            |  | Fit/Function <input type="checkbox"/>                                                                           |  | Off-set/Set-up <input type="checkbox"/>                                                                                              |  |                                                                                                                                                     |  |                        |  |
|                                                                                                                                                                                                                                                                                                                                                                                                                                   |  |                                                                                                         |  | Other/Details:                                                                                                 |  |                                                                                                                 |  |                                                                                                                                      |  |                                                                                                                                                     |  |                        |  |
|                                                                                                                                                                                                                                                                                                                                                                                                                                   |  |                                                                                                         |  |                                                                                                                |  |                                                                                                                 |  |                                                                                                                                      |  |                                                                                                                                                     |  |                        |  |
|                                                                                                                                                                                                                                                                                                                                                                                                                                   |  |                                                                                                         |  |                                                                                                                |  |                                                                                                                 |  |                                                                                                                                      |  |                                                                                                                                                     |  |                        |  |